



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2196-2
Job Sheet 174337



Part No: D2196-2

Job Qty: 4 ea

Part Name: Bracket



Part Weight: 0 lbs

Job Created: 3/14/18

Due Date: 3/30/18

Type: SOLD

Ship March 29

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Note: DWG REV D IPP Rev:A 08-07-24 new issue ec verified by:dd

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		3/29/18	0.00	0.00	Start Up Waterjet		<i>SC 18/03/18</i>
110	Waterjet	4 pcs		3/29/18	0.00	0.33	Waterjet 2 OMAX		<i>SC 18/03/18</i>
120	QC	4 pcs		3/29/18	0.00	0.00	QC2 Waterjet-4		<i>SL 18/03/18</i>
130	QC	4 pcs		3/29/18	0.00	0.00	QC8-6		<i>38</i>
140	Brake NC	4 pcs		3/30/18	0.00	0.40	Brake NC 2		<i>9-88</i>
150	QC	4 pcs		3/30/18	0.00	0.00	QC5		<i>25</i>
160	Packaging	4 pcs		3/30/18	0.00	0.00	Packaging3	<i>5/2003 rd</i>	<i>APR 05 2018</i>
190	QC21-SA	4 Ea		3/30/18	0.00	0.00	QC21		<i>APR 05 2018</i>

Part Op **110** - 1-Cut as per Dwg Dwg Rev: *0* Prog Rev: *10* 2-Deburr if necessary (Red Barn folder)
Descriptions: **140** - Bend as per dwg D2196

DAS 21 9-88 *APR 05 2018*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.8440 sf (.211 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S16GA	1	267	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐															
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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S052480 Part: D2196-2 Job No: 174337 Serial No/Batch: S052480 Revision: D Inspector: _____ Date: 03/18/18				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																															
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DART AEROSPACE LTD		Work Order: 174337
Description: Bracket		Part Number: D2196-2
Inspection Dwg: D2196	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	Ø0.132	1		VDC-01	
Ø0.203	+0.005/-0.001	Ø0.205	1			
Ø0.316	+0.006/-0.001	Ø0.319	1			
0.375	+/-0.010	0.379	1			
0.813	+/-0.010	0.817	1			
1.750	+/-0.010	1.754	1			
2.688	+/-0.010	2.689	1			
3.625	+/-0.010	3.628	1			
4.000	+/-0.010	4.003	1			
0.375	+/-0.010	0.378	1			
1.200	+/-0.010	1.202	1			
2.390	+/-0.010	2.394	1			
3.960	+/-0.010	3.966	1			
5.530	+/-0.010	5.535	1			
6.730	+/-0.010	6.733	1			
7.230	+/-0.010	7.232	1			

Measured by: SC	Audited by: 38	Prototype Approval:	N/A
Date: 18/03/18	Date: MAR 19 2018	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.08.27	New Issue	KJ/DD	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

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Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
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